

July 8, 2009 1:43:59 PM

Item ID:

D3065-7

В

**Revision ID:** Item Name:

Step Spacer

**Start Date:** 

07/08/2009

**Start Qty: 40.00** 

**Required Date: 07/15/2009** 

Req'd Qty: 40.00



Accept

Setup Start

Stop



Reference:

Approvals:

Process Plan: MF

Date: 09-07-08Tooling:

Date: Date: Run

Start

Stop



QC:

Operation

Description

Set Up/ **Run Hours** 

SPC (Y/N):

Draw Number

**Cust Item ID:** 

**Customer:** 

Draw Rev.

Plan Accept Code Qty

Reject Qty

Reject Insp. Stamp Number

**Draw Nbr** 

Sequence ID/

Work Center ID

**Revision Nbr** 

D3065 Rev B

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3065 []Dwg Rev: R

Date:

\_[]Prog Rev: **ß** 



110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Deburr if necessary

0.00

0.00

0.00

0.00



120

QC

Quality Control

QC8- Inspect parts - second check

Memo

Memo



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Accept

Setup Start

Stop



**Required Date:** 07/15/2009

Req'd Qty: 40.00



**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

Date: \_\_\_ Tooling:

Date:

Run

Start



Date: SPC(Y/N):

Date:

Stop



Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Deburr if necessary.

Set Up/ Run Hours

Draw Number

Draw Rev.

Plan Code Accept Qty

Reject Reject Qty

Insp. Number Stamp

140

Brake NC

Brake NC

NC BRAKE

Memo

Memo

Bend as per Dwg D3065

0.00

0.00

8 29/07/13

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

### Work Order ID 50146

В

July 8, 2009 1:43:59 PM

Page 3

Item ID:

D3065-7

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: Step Spacer

**Required Date:** 07/15/2009

**Start Date:** 

07/08/2009

**Start Qty: 40.00** 

Req'd Qty: 40.00

**Cust Item ID:** 

**Customer:** 

Draw

Number

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Run Start

Accept

Qty



QC:

Date:

SPC (Y/N):

Date:

Draw

Rev.

Plan

Code

Stop

Reject

Qty

Insp.

Stamp

Reject

Number

Sequence ID/ **Work Center ID** 

160



Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours** 

0.00

0.00

170

Quality Control

QC3- Inspect Part Finish

0.00

Memo 09-07 1440

180

Packaging Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00



DART AEROSPACE LTD	Work Order: SO146
Description: STEP Spaces	Part Number: D3065-7
Inspection Dwg: 03065 Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	loierance	Dimension	Accept	Heject	Inspection	
\$ 1.250	10.012-0.001	1.250	V		YENN	
Ø 0.128	+0.005-0.601	0.131	1		VWN	
4.500	+1-0.010	4518	<b>/</b>		VerN	
4.186	11-0.010	4.189	V		MMN	
2.093	+1-0.010	2.092	V		VWN	
0.250	4-0.010	0.250	1		VerN	
3.936	+1-0.010	3.940	1		VEVN	
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Measured by:	mM	Audited by:	Prototype Approval:	1.	
Date:	09.07.09	Date: (29/1)	Date:	(	4

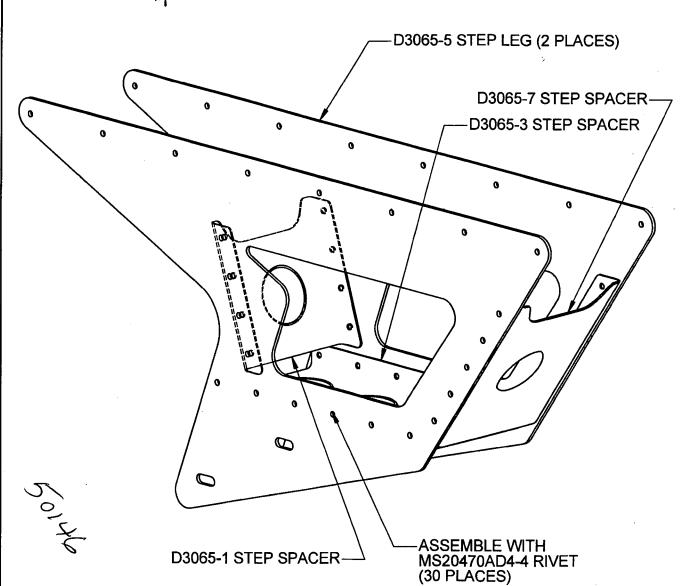
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



				•			
DESIGN PRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECK	ED	APPROVED	DRAWING NO.	REV. B			
	PH		D3065	SHEET 1 OF 5			
DATE	00.0	)F 00	TITLE	SCALE			
06.05.23			STEP LEG ASSEMBLY	1:2			
Α	02.09.11		NEW ISSUE				
В	0	6.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-				

## RELEASED

06 ch 20 Aff



# D3065-041 STEP LEG ASSEMBLY

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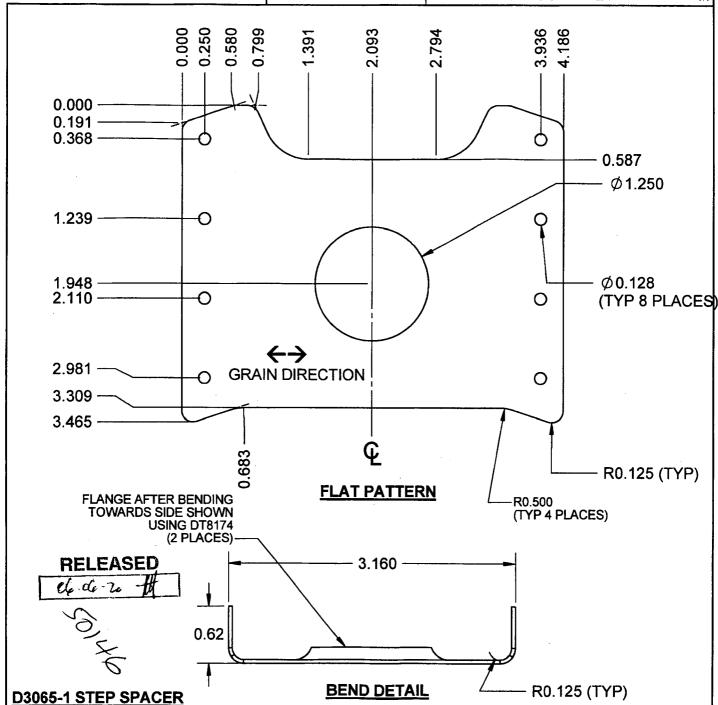
W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	
	Resolution:		Disposition:	QA: N/C Closed	] <b>.</b>	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B			Verification	Approval	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto	
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- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

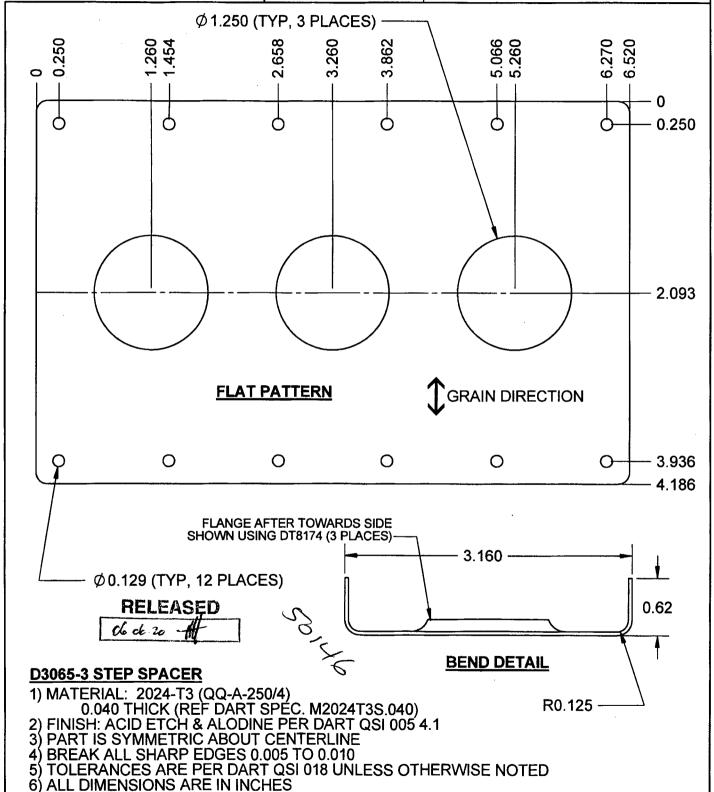
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	Res	solution:	Disposition: QA: N/0			A: N/C Closed: Date:			
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
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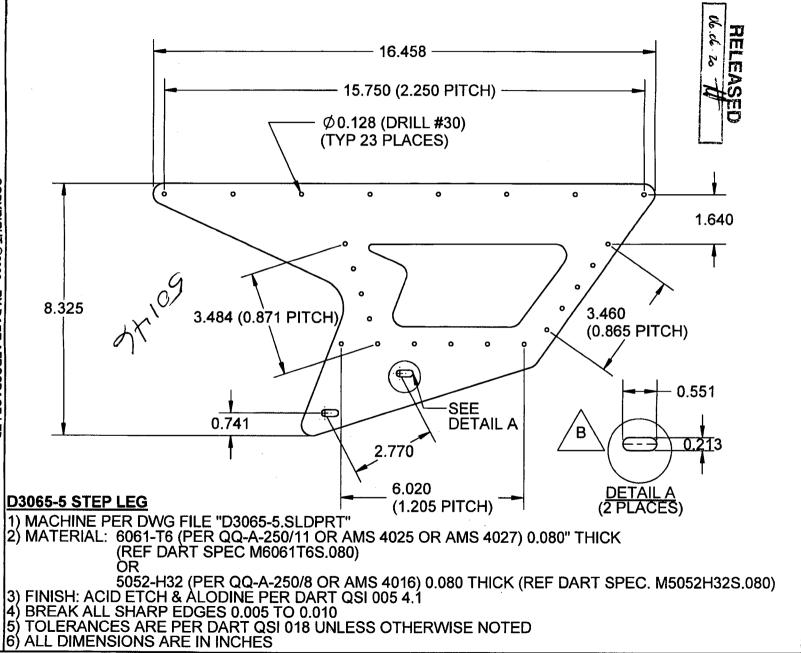


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		Description of NC	Corrective Action Section B		Vei		ification	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8	) <u> </u>	on C	Chief Eng	QC Inspector
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SHOKE SHOKE 06.05 12 23 DRAWING NO. STEP LEG DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA **ASSEMBLY** SHEET 4 OF 5 REV. B SCALE

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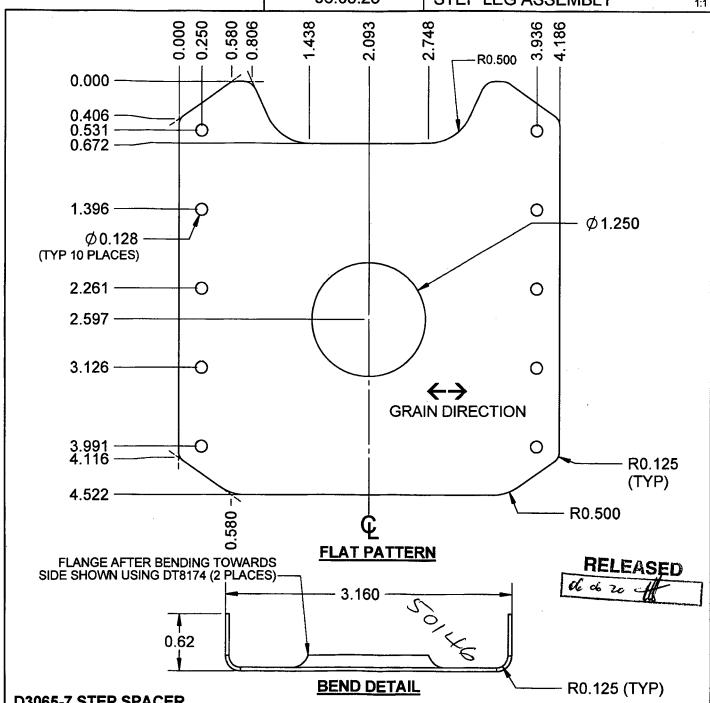
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W/O:			W	ORK ORDER CHANG	ES					
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## **D3065-7 STEP SPACER**

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- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
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Part No	) <u>.</u>	PAR	#: Fault Ca	ategory:	NC	R: Yes	No DQ	Δ-	Date:	
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Annuaval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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